



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5506-1**Job Sheet 196941**

Part No: D5506-1

Job Qty: 4 pcs

Part Name: Base, Lower Cutter



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/25/19

Job Tracking No:

Due Date: 7/5/19

Created By: Kimberley Guerin

Type: SOLD

Description:

Ship Via:

Bill of Materials**Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	4 pcs	7/5/19	7/5/19	0.00	0.16	Bandsaw - 1		JS 19-07-16
105	HAAS 5 Axis - B4B	4 pcs	7/5/19	7/5/19	0.75	4.00	HAAS - 5 - B4B		
110	QC 2	4 pcs	7/5/19	7/5/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		JS 19-07-16
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		



Container No: S198421



Part: D5506-1

Job No: 196941

Serial No/Batch: S198421

Revision: A

Inspector:

Exp Date:

Instructions:

Date: 07/16/19

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

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P.T.O.

				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
117 QC 8	4 pcs	7/5/19	0.00 0.00	QC 8 - 12	9/19/10/21/16
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
120 Outsource - 4 - Anodize	4 pcs	7/5/19	0.00 0.00	ATG001	2019-07-17
130 Packaging 2-1 - Receive - B4B	4 pcs	7/5/19	0.00 0.00	Packaging 2 - 1 - B4B	JUL 24 2019
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	

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140 QC 5	4 pcs	7/5/19	0.00 0.00	Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	DAS
				QC 5 - 24	61
				QC 5 - 3	9-89
170 Packaging 3-1 - Stock - B4B	4 pcs	7/5/19	0.00 0.00	QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	0-2 B'n: cck009
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	

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190 QC 21 - SA	4 pcs	7/5/19	0.00 0.00	Packaging 3 - 36 - B4B	
				QC 21 - SA - 21 →	Bin: CCK009
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - Bandsaw - CUT AT 7.100" LONG
 Descriptions: 105 - HAAS CNC vertical machine #5 - 1-Machine per folio FB546 DWG REV: A FOLIO REV: 1A 2-
 Deburr and break all sharp edges
 110 - QC2- Inspect parts off machine FAI/FAIB
 117 - QC8- Inspect parts - second check
 120 - Outsource process-Anodize per QSI017 4.1.10.1 - Issue P/O to ATG: 44033 HARD ANODIZE COLOR
 BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N ***1-2 MIL MAX
 AS PER QSI005*** Certification of Conformity is required
 130 - Receive & Inspect for Damage & Mat'l Certs
 140 - QC5- Inspect part completeness to step on W/O
 170 - Identify as per dwg & Stock Location:
 190 - QC21- Final Inspection - Work Order Release

JUL 25 2019

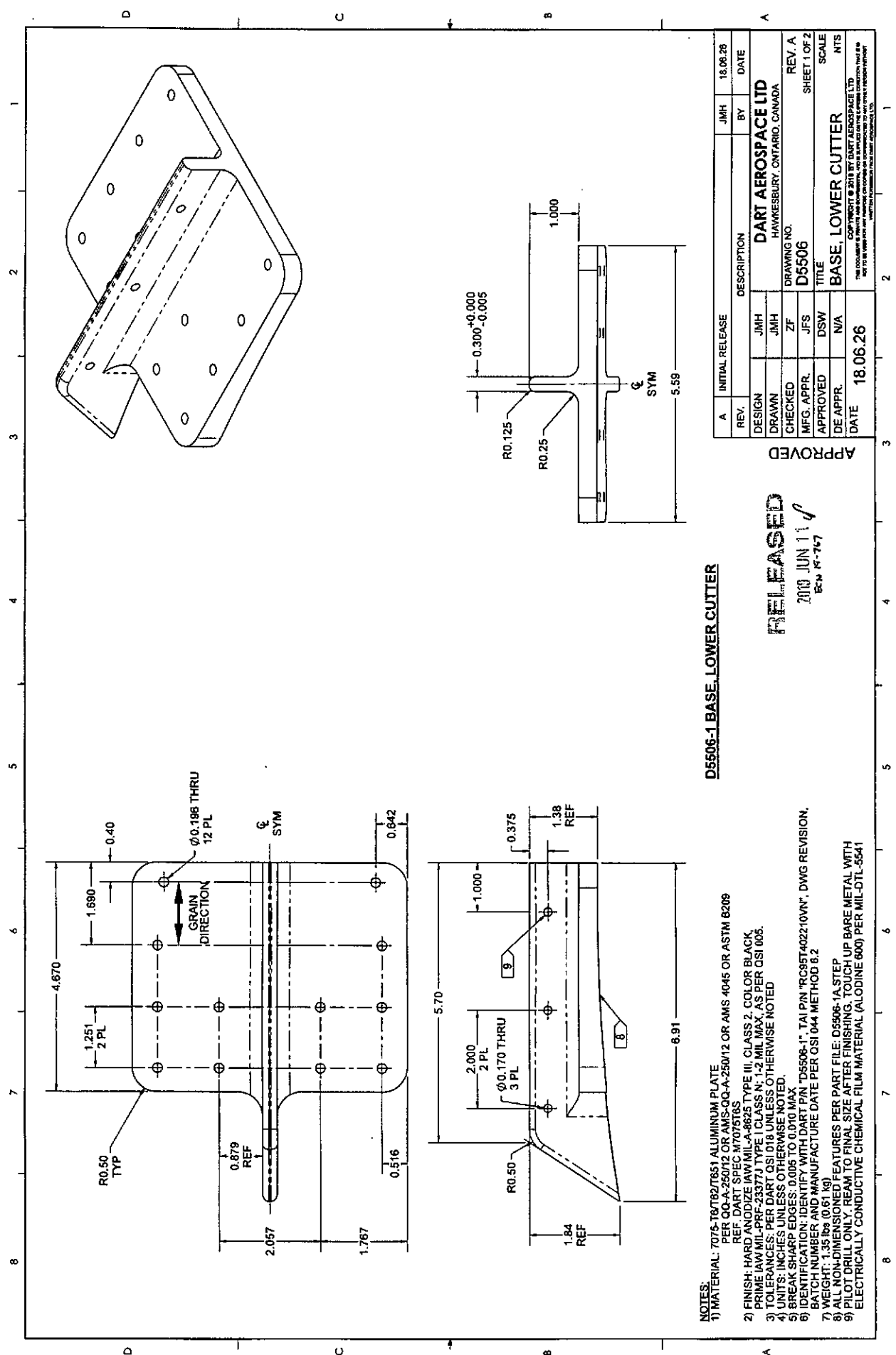
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M7075T6S2.000X6.000	7075-T6S Sheet 2.000" Thick X 6.000" Wide	2.4000 ft (.6 ea)	100-Bandsaw - 1	FM138287

~~2.4000~~ 3.000' used

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M7075T6S2.000X6.000	2	11	0

Part Specifications	
Specifications could not be found.	

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NOTES:
1) MATERIAL: 7075-T6/T62/TS1 ALUMINUM PLATE
PER QQ-A-250/12 OR AMS-QQ-A-250/12 OR AMS 4045 OR ASTM B209
REF. DART SPEC M7075TS8
2) FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK
PRIME IAW MIL-PRF-23373 TYPE I CLASS N: 1/2 MIL MAX, AS PER QSI 005.
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5506-1", TAI P/N "RC95T402210VN", DWG REVISION,
BATCH NUMBER AND MANUFACTURE DATE PER QSI 044 METHOD 6.2
7) WEIGHT: 1.35 lbs (0.61 kg)
8) ALL NON-DIMENSIONED FEATURES PER PART FILE: D5506-1A STEP
9) PILOT DRILL ONLY. REAM TO FINAL SIZE AFTER FINISHING. TOUCH UP BARE METAL WITH
ELECTRICALLY CONDUCTIVE CHEMICAL FILM MATERIAL (ALODINE 600) PER MIL-DTL-5541

D5506-1 BASE, LOWER CUTTER

RELEASED
2019 JUN 11
EIA 9-747

APPROVED

REV.	DESCRIPTION	DATE
A	INITIAL RELEASE	18.06.26
DESIGN	JMH	BY
DRAWN	JMH	DATE
CHECKED	ZF	
MFG. APPR.	JFS	
APPROVED	DSW	
DE APPR.	N/A	
DATE	18.06.26	
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWING NO. D5506		
REV. A		
SHEET 1 OF 2		
SCALE		
NTS		
BASE, LOWER CUTTER		
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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: 2R Date: Oct 16/19

Work Order update only

Work Order: <u>196 941</u>		DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. <u>D5506-1</u>		Rework ☐ Scrap ☒ Use-as-is ☐		Cross tube		Water Jet	
NCR No. <u>19-7415</u>		Suspected Unapproved		Machining		Prod. Eng. Coord.	
Date: <u>19-07-14</u>		Step #: <u>105</u>		Thermoforming		Rec/Store/Packaging	
Description Work Order Deviation		QTY Effective: <u>1</u>		Large Fab		Supplier	
Disposition		Disposition		Composite		Engineering	
Completed By		Completed By		Finishing		Quality	
Lead hand / Supervisor		Lead hand / Supervisor		Other		Other	
Approval		Approval		Approval		Approval	
Program & Drawing do not match.		Scrap & Replace		DAS		DAS	
Drawing has less holes, different positions, different overall widths		B: FM 138 287		20 19-07-16		20 19-07-16	
Program was updated to match with latest rev. 19/07/15 AFS		Program was updated to match with latest rev. 19/07/15 AFS		QC / Coordinator		QC / Coordinator	
Root Cause		Root Cause		Root Cause		Root Cause	
Environment		Environment		Environment		Environment	
Design		Design		Design		Design	
Doc/Data		Doc/Data		Doc/Data		Doc/Data	
Equip/Tooling		Equip/Tooling		Equip/Tooling		Equip/Tooling	
Handling/Pre		Handling/Pre		Handling/Pre		Handling/Pre	
Material		Material		Material		Material	
Internal Transport		Internal Transport		Internal Transport		Internal Transport	
Tribal Knowledge		Tribal Knowledge		Tribal Knowledge		Tribal Knowledge	
LOA		LOA		LOA		LOA	
Substation		Substation		Substation		Substation	
Past Expiry Date		Past Expiry Date		Past Expiry Date		Past Expiry Date	
Misidentified		Misidentified		Misidentified		Misidentified	
No Re-verification		No Re-verification		No Re-verification		No Re-verification	
Operator		Operator		Operator		Operator	
Offset/Setup		Offset/Setup		Offset/Setup		Offset/Setup	
Supplier		Supplier		Supplier		Supplier	
Training		Training		Training		Training	
Use for Testing		Use for Testing		Use for Testing		Use for Testing	
Poor Information		Poor Information		Poor Information		Poor Information	
Rushing		Rushing		Rushing		Rushing	
Product Improvement		Product Improvement		Product Improvement		Product Improvement	
Process Improvement		Process Improvement		Process Improvement		Process Improvement	
Manufacturing Process		Manufacturing Process		Manufacturing Process		Manufacturing Process	
Past Due		Past Due		Past Due		Past Due	
OTHER:		OTHER:		OTHER:		OTHER:	
Pressure/Forced		Pressure/Forced		Pressure/Forced		Pressure/Forced	
Bending		Bending		Bending		Bending	
Centre Not Concentric		Centre Not Concentric		Centre Not Concentric		Centre Not Concentric	
Cracks		Cracks		Cracks		Cracks	
Crimp/Kink/Ripple/Wave		Crimp/Kink/Ripple/Wave		Crimp/Kink/Ripple/Wave		Crimp/Kink/Ripple/Wave	
Cuffs		Cuffs		Cuffs		Cuffs	
Crushing		Crushing		Crushing		Crushing	
Heat Treat		Heat Treat		Heat Treat		Heat Treat	
Wave/Twist in Tube		Wave/Twist in Tube		Wave/Twist in Tube		Wave/Twist in Tube	
Marks/Chatter		Marks/Chatter		Marks/Chatter		Marks/Chatter	
Temperature/Cure		Temperature/Cure		Temperature/Cure		Temperature/Cure	
Set-up		Set-up		Set-up		Set-up	
BOM/Route		BOM/Route		BOM/Route		BOM/Route	
Broken/Damage/Defect		Broken/Damage/Defect		Broken/Damage/Defect		Broken/Damage/Defect	
Inspection Incomplete/Unqualified		Inspection Incomplete/Unqualified		Inspection Incomplete/Unqualified		Inspection Incomplete/Unqualified	
Contamination		Contamination		Contamination		Contamination	
Countersink		Countersink		Countersink		Countersink	
Cut Too Short		Cut Too Short		Cut Too Short		Cut Too Short	
Instructions Incomplete/Unclear		Instructions Incomplete/Unclear		Instructions Incomplete/Unclear		Instructions Incomplete/Unclear	
Drill Holes		Drill Holes		Drill Holes		Drill Holes	
Power Loss/Program		Power Loss/Program		Power Loss/Program		Power Loss/Program	
Grain		Grain		Grain		Grain	
Weld		Weld		Weld		Weld	
Wrong Stock Pulled		Wrong Stock Pulled		Wrong Stock Pulled		Wrong Stock Pulled	
Out of Sequence		Out of Sequence		Out of Sequence		Out of Sequence	
Off-set		Off-set		Off-set		Off-set	
Mislabeled		Mislabeled		Mislabeled		Mislabeled	
Fit/Function		Fit/Function		Fit/Function		Fit/Function	
Misaligned/off center		Misaligned/off center		Misaligned/off center		Misaligned/off center	
Positioned Wrong		Positioned Wrong		Positioned Wrong		Positioned Wrong	
Outside Dimensions		Outside Dimensions		Outside Dimensions		Outside Dimensions	
Over/Under tolerance		Over/Under tolerance		Over/Under tolerance		Over/Under tolerance	
Part Incorrect		Part Incorrect		Part Incorrect		Part Incorrect	
Part Lost/Missing		Part Lost/Missing		Part Lost/Missing		Part Lost/Missing	
Part Moved		Part Moved		Part Moved		Part Moved	
Drawing		Drawing		Drawing		Drawing	
Finish		Finish		Finish		Finish	
Misread		Misread		Misread		Misread	
Turning Sequence		Turning Sequence		Turning Sequence		Turning Sequence	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB044033**



Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044033
PO Date: 7/17/19
Due Date: 7/23/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pymt Terms: Net 30

Freight Terms:
Special Comments: ***RUSH***

E-MAILED
2019-07-19

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	196941	D5506-1	Base, Lower Cutter Outsource process-Anodize per QSI017 4.1.10.1 - Issue P/O to ATG: HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N ***1-2 MIL MAX AS PER QSI005*** Certification of Conformity is required	Firmed	-	7/23/19	4 pcs	0 pcs	4 pcs	\$20.71/pcs	\$82.84
2	196945	D5502-5	Windshield Deflector Doubler Outsource process-Anodize per QSI017 4.1.10.1 - Issue P/O to ATG: HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 3 CLASS 2 PRIME AS PER IAW MIL-PRF-23377J TYPE 1 CLASS N (1-2 MIL MAX) C OF C IS REQUIRED	Firmed	-	7/23/19	10 pcs	0 pcs	10 pcs	\$12.74/pcs	\$127.40
3	196946	D5502-7	Windshield Deflector Upper Tab Outsource process-Anodize per QSI017 4.1.10.1) - Issue P/O to ATG: HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 3 CLASS 2 PRIME AS PER IAW MIL-PRF-23377J TYPE 1 CLASS N (1-2 MIL MAX) C OF C IS REQUIRED	Firmed	-	7/23/19	10 pcs	0 pcs	10 pcs	\$12.74/pcs	\$127.40



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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044033



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	196948	D5502-11	Curved Doubler Outsource process-Anodize per QSI017 4.1.10.1 - Issue P/O to ATG: _____ HARD ANODIZE COLOR BLACK, PER IAW MIL-A- 8625F TYPE 3 CLASS 2 PRIME AS PER IAW MIL- PRF-23377J TYPE 1 CLASS N (1-2 MIL MAX) C OF C IS REQUIRED	Firmed	-	7/23/19	10 pcs	0 pcs	10 pcs	\$12.74/pcs	\$127.40
Grand Total:											\$465.04

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 7/19/19 9:48 AM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918261

Date: 23-Jul-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

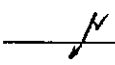
Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
✓ 4 ea	Part: D5506-1 Base, Lower Cutter Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils). Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 25500 PO: POHB044033 ✓	Rev: Line: 1	DAS 61 9-89
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>JUL 23 2019</u> Certified Signature: <u></u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
RECEIVED JUL 23 2019 DART AEROSPACE LTD.			

Made in Canada.